Work Orde March-04-14 3:	er ID 114389 -04:18 PM			*112	1389*						Page 1
Item ID: Revision ID: Item Name:	D3650-041 Tunnel Top Panel Asser	mbly (	7	Accept	*N900	040	100	)*	Setup Star	17	S1* S2*
Start Date: Required Date: Reference:		Qty: 1.00 Qty: 1.00	*1* *1*		Cust Item Customer:						
Approvals:	Process Plan:					ate:	_	1	Run Star Stoj	<b>''IV</b>	R1*
Sequence ID/ Work Center II	Operat			Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	R2* Insp. Stamp
Draw Nbr	Revision N	or									
D3650	Rev E	V									
*1 \\n^* Packaging Packaging	Pick Kit	Мето		0.00					FF		OCT 15 2014
110 *110*	Small Fe	Ib		0.00				9			OCT 15 2014
Small Fab Small Fab		Memo 1-Assemble	e as per dwg D36502- Seal	0.00 all mating surfaces and a	all gaps using					· ·	_
120 *1 20*	QC5- In	Proseal 700	of the second of	g D3650Batch: <u>H / 3 6</u>	<u>0</u> 403		DAS 30 9-89	2			14/10

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Memo

Quality Control

DQA:			_ Date: _													
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QA Closed:			Date:							W	ork Order up	odate only				
Work Orde	er:					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS		:		
	_					Rework	1		Skid-tube Crosstube		]	Water Jet		Engineering		
Part N	١o.					Scrap	1		Machining Small Fab	<u> </u>	Pro	d. Eng. Coor.	Quality			
•	· -				•	Use-as-is	1	Therr	noforming Finishing	3	4	re/Packaging	$\neg$	Other		
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	<u> 1</u>	QC Inspector		
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	-	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa	are		Part Incorred	ct		Temperature/Cure		
	$\neg$		nk/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld		
	_	Cuffs			ļ	Contamination	_	1	tions Incomplete/Unclear	ļ	Part Moved			Wrong Stock Pulled		
,	_	Crushing			ļ	Countersink		1 7	gned/off center		Positioned V	· · ·				
	_	Heat Trea				Cut Too Short	<u></u>	Mislabe		<u></u>	Power Loss/	Surge		Other		
	_	-	n Strip in	Tube		Drawing	<u></u>	Misread								
	_	Marks/Ch			-	Drill Holes	<u> </u>	Off-set								
	_	Turning S			-	Finish	_	1	Calibration							
Wave/Twist in Tube						Fit/Function	1	IOut of 9	Sequence							

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\*114389\*

Page 2

March-04-14 3:04:18 PM Item ID: D3650-041 Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Tunnel Top Panel Assembly **Start Date:** Start Oty: 1.00 \*1\* 04/03/2014 **Cust Item ID: Required Date:** 04/03/2014 Reg'd Oty: 1.00 \*1\* **Customer:** Reference: Start Run Process Plan: Date: **Approvals: Tooling:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Qty Number Stamp **Run Hours** Code Qty Identify as per dwg & Stock Location: 6. A 130 0.00 \*120\* OCT 1 5 2014 Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* OC 0.00 Memo Quality Control

14/10/16 g My-10:16

DQA:			Date:													
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE			AEROSPACE			
QA Closed:			Date:							W	ork Order up	odate only				
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	•					Rework			Skid-tube	Crosstube	7	Water Jet Engineering				
Part N	lo.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other			
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		Crushing Heat Trea	ıt		-	Cut Too Short	-	Mislabe	ned/off center	-	Positioned V		Joshan			
		Inspection		Tuhe		Drawing	ļ	Misread		L	Power Loss/	Juige	Other			
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## **Picklist Print**

March-04-14 3:04:17 PM

Work Order ID: 114389

\*114389\*

Parent Item:

D3650-041

\*D3650-041\*

Parent Item Name: Tunnel Top Panel Assembly

**Start Date:** 04/03/2014

**Required Date:** 04/03/2014

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A New Issue 07-11-12

IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC

EC verified by: DD

IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date State	us
AN3C3A *AN3C3A* Bolt		Purchased	No		,	110	Each	1,166.000	**	8 F	F	OCT 15 2	2014
				Location ST350	122141 124417		Oty 1166 6 1160	Loc Code	_ _ _	16	 		
*D3650-1 *D3650-1* Aft Panel		Manufactured	No	1101	42	110	Each	0.0000	**	1	FF	OCF 1	1 5 <b>26</b> 1
03650-3 *D3650-3* Center Panel		Manufactured	No	109		110	Each	0.0000	**	<i>i</i> <sup>1</sup>	FF	UU 1	. 5 26
D3650-5 <b>*D3650-5*</b> Fwd Panel	. •	Manufactured	No			110	Each	2.0000	1 <b>**</b>	1	FF	001	Γ <u>15</u> 2

Location Loc Qty Loc Code ST189 2 2 94570

DQA:			Date:												T@AC
0.4.61			D - 4 -			WORK ORDER NON-	-C(	ONFO	RMANCE / U		147	101		_	AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION				PROCESS					
	-					Rework	Skid-tube Crosstube						Water Jet	$\neg$	Engineering
Part I	Vo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	1	Quality
	-					Use-as-is			noforming	Finishing	H		e/Packaging	7	Other
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
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Equip/Tooling	Ц														
Handling/Pre		•	<u>'</u>												
Material	Ш														
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Offset/Setup	Ш										- 1				
Process	Ш				:	•	1								
Supplier -	Ш														
Training	Ш														
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	Cracks					Broken/Damage/Defect	<u> </u>	Hardwa			$\vdash$	Part Incorred		— 1	emperature/Cure
	-	Crimp/Kii	nk/Ripple	/Wave		Burrs	<u> </u>	1	ion Incomplete/U			Part Lost/Mi	ssing	_	'eld
	$\vdash$	Cuffs				Contamination	_	1	ions Incomplete/	Unclear	-	Part Moved	L	]W	rong Stock Pulled
	-	Crushing				Countersink	<u> </u>	1 -	ned/off center		-	Positioned V			
	-	Heat Trea				Cut Too Short	L	Mislabe			Ш	Power Loss/Surge			ther
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	_	Marks/Ch			<u> </u>	Drill Holes	_	Off-set				<u> </u>			
	$\vdash$	Turning S	•		<u> </u>	Finish	<u> </u>	4	Calibration						
l	1 1	Wave/Tu	ist in Tub	ne ne	1	Fit/Function	1	IOut of 9	Sequence						

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## **Picklist Print**

March-04-14 3:04:18 PM

Page 2

Work Order ID: 114389

D3650-041

Parent Item Name: Tunnel Top Panel Assembly

\*114389\* \*D3650-041\*

**Start Date:** 04/03/2014

**Required Date:** 04/03/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Parent Item:

Purchased

No

100

Each

976.0000

Loc Code

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OCT 15 2014

\*NAS1149C0363R\*

Location Loc Qty 128591 FP001 698 114742 698 ST292 278 122441 278



DQA:			. Date:										A A DT		
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	udata only	AEROSPACE		
QA Closed.			Date.							VV	ork Order up	date only			
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
		•				Rework		Skid-tube	Crosstube	1	Engineering				
Part N	Vo.					Scrap			Machining						
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	$\vdash$	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	t	Temperature/Cure		
	-		nk/Ripple,	/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld		
	$\vdash$	Cuffs				Contamination	-	1	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled		
	_	Crushing	_		_	Countersink	_	_	ned/off center	<u> </u>	Positioned V		<del></del>		
	$\vdash$	Heat Trea		<b>-</b> .	<u> </u>	Cut Too Short	-	Mislabe		L	Power Loss/	Surge	Other		
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